

Date: Thursday, 3/27/2008 7:41:52 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP BRACKET
Job Number : 38223	
Estimate Number : 13160	
P.O. Number :	Part Number : D37281
This Issue : 3/27/2008 S.O. No. :	Drawing Number : D3728 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 37579	Material :
Written By :	Due Date : 4/2/2008 Qty: 8 Um: Each
Checked & Approved By : <u>JD 08-3-27</u>	
Comment : Est Rev:A 08-01-30 new issue DD verified by:EC	
Est Rev:B 08-02-26 ECN 1140p DD verified by:	
Est Rev:C 08-03-19 chg to revB ecn1158 DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X06000	6061-T6 Bar .25" x 6.0"
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IB



Comment: Qty.: 1.3484 f(s)/Unit Total : 10.7873 f(s)
 6061T6 aluminium bar 6.00" X .250" thick
 (M6061T6B0250X06000)
 Batch: 107130 IB 8-3-28

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3728
 Dwg Rev: B
 Prog Rev: B

IB 8-3-28

2- Deburr if necessary

IB 8-3-28

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-3-28



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/03/28 (12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-open holes to finish size as per dwg D3728

CB 08/03/31 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3728-1 PAR #: N/A Fault Category: Prod / Mfg Ass ^{made small water jet} NCR: Yes No DQA: D Date: 08/04/04
D205541 QA: N/C Closed: HP Date: 08/04/04

NCR: <u>38223</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/03/28</u>	<u># 2.0</u>	<u>one part scrap. Chatter marks are too Deep from water jet R.C. mat. Did not set plate</u>	<u>08.03.28</u>	<u>Scrap and Destroy Qty (X1) NO Replne.</u>	<u>HB 8-3-28</u>	<u>08/03/28</u>	<u>08.03.28</u>	<u>08/03/28</u>

NOTE: Date & initial all entries

Date: Thursday, 3/27/2008 7:41:52 AM
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Drawing Name: STEP BRACKET

Job Number: 38223

Part Number: D37281

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Deburr if necessary

3- grind water jet marks all around bracket smooth

****do not grind inside where step extrusion goes****

CB 08/03/31 (12)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/31 (12)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-03-31 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/03/31 (12x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: CA

SS 08/03/31 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/03

Job Completion



mf 08-03-31

W

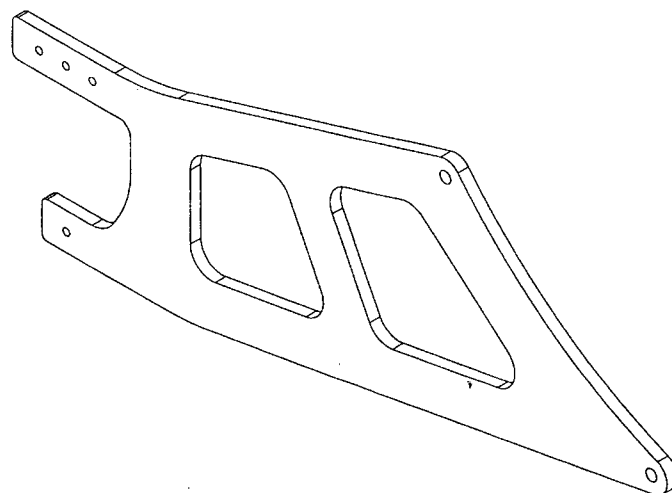
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



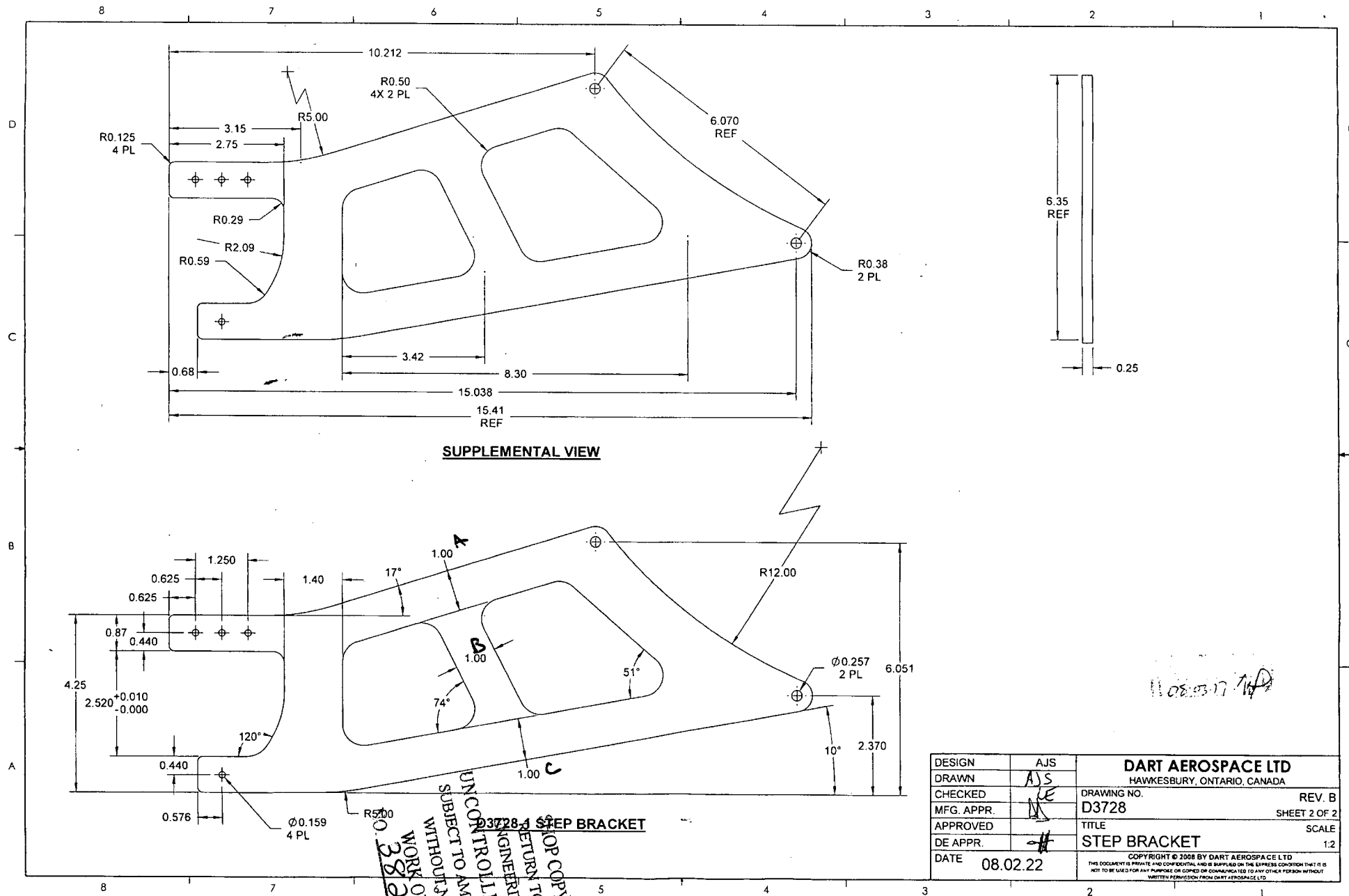
D3728-1 STEP BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.250)
- OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.93 lbs

NO. 32023
 WORK ORDER
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B	SHEET 2 ZONE A4, Ø0.257 HOLE WAS Ø0.191, A8, 2.520 DIM WAS 2.51 & TOLERANCE HAS BEEN UPDATED. ZONE A7 & B8 Ø0.159 HOLES ADDED.	AJS	08.02.22
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	415		
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	ME	D3728	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.	#	STEP BRACKET	NTS
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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	KE	D3728	SHEET 2 OF 2
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	STEP BRACKET	1:2
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DART AEROSPACE LTD		Work Order: 38023
Description: STEP BRACKET		Part Number: D3728-1
Inspection Dwg: D3728-1 Rev: 1 b		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.59	+ .005 - .001					
Ø 2.57	+ .006 - .001					
15.41	+/- .030	15.41	*			
15.038	+/- .010	15.038	*			
10.712	+/- .010	10.712	*			
2.75	+/- .030	2.753	*			
.68	+/- .030	.694	*			
A 1.00	+/- .030	1.015	*			
B 1.00	+/- .030	1.018	*			
C 1.00	+/- .030	1.016	*			
.576	+/- .010	.575	*			
.440	+/- .010	.437	*			
2.520	+/- .010	2.517	*			
.87	+/- .030	.874	*			
.440	+/- .010	.438	*			
4.25	+/- .030	4.26	*			
.625	+/- .010	.628	*			
.625	+/- .010	.628	*			
1.250	+/- .010	1.253	*			
1.40	+/- .030	1.41	*			
6.051	+/- .010	6.051	*			
2.370	+/- .010	2.371	*			

Measured by: RB	Audited by:	Prototype Approval:
Date: 8-3-08	Date: 08/03/08	Date: 1/17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	